

Work Order ID 58343

Monday, May 03, 2010 2:58:41 PM



Page 1

Item ID: D3909-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Lug Assembly, Fwd

Start Date: 5/10/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 5/14/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

MF

Date: 10-5-3

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3909

B

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

ES 10/05/27 (6)

110

0.00



Small Fab

Memo

0.00

Small Fab

1- Assemble as per dwg
Trim rivet to 1.185" long*ES 10/05/27 (6)*

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*8 w/05/27**(76)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: 476

0.00



Packaging

Memo

0.00

Packaging

16-5-27

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/31
MF
10-5-27

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Picklist Print

Monday, May 03, 2010 2:58:40 PM

Page 1

Work Order ID: 58343

Parent Item: D3909-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Comments: IPP RevA: New issue DD verified by:EC
per dwg revB DD 10.04.20 verified by:EC

IPP Rev:B as

Start Date: 5/10/2010

Required Date: 5/14/2010

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D2690-6 Lanyard Assembly		Manufactured	No			100	Each	5.0000	1		5/10/05/27 B58375 (6x)	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				ST021		.5						
					50665	5						
D3909-1 Lug Plate, Fwd Crosstube		Manufactured	No			100	Each	6.0000	2		5/10/05/27 B58339 (12x)	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				ENG		2						
					55704	2						
				ST095		4						
					57824	4						
D3909-3 Fwd Lower Attach Arm		Manufactured	No			100	Each	2.0000	1		5/10/05/27 B58340 (6x)	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				ST095		2						
					56952	2						
D3909-5 Eyebolt Stud		Manufactured	No			100	Each	0.0000	1		5/10/05/27 B58240 (6x)	
D3910-1 Crosstube Lug		Manufactured	No			100	Each	12.0000	2		5/10/05/27 B58341 (12x)	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				ENG		12						
					57194	12						

W/O:		WORK ORDER CHANGES					
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Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D3917-1 Washer		Manufactured	No			100	Each	74.0000	2		5/10/05/27	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				ST065				40				
					57821			40				
				ST096				34				
					57830			34				
AN3C12A Bolts		Purchased	No			100	Each	176.0000	4		5/10/05/27	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				ST351				176				
					112314			176				
AN3C13 Bolt		Purchased	No			100	Each	38.0000	1		5/10/05/27	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				ST351				38				
					114304			38				
MS17984-C413 PIN, QUICK RELEASE		Purchased	No			100	Each	27.0000	1		5/10/05/27	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				ST297				4				
					114340			4				
				ST314				23				
					114495			3				
					114523			20				

114773 (42)

Monday, May 03, 2010 2:58:40 PM

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Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
MS20615-4220 RIVET	4/1/18 M11 4506	Purchased	No			100	Each	204.0000	3		5/10/05/27	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				ST323		204						
				113254		16						
				114324		4						
				114349		184						
AN310C3 Castellated Nut		Purchased	No			100	Each	38.0000	1		5/10/05/27	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				ST349		38						
				114304		38						
MS21043-3 Nut		Purchased	No			100	Each	3,735.000	4		5/10/05/27	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				FG		80						
				103691		80						
				ST301		3655						
				112314		3655						
MS24665-151 Cotter Pin		Purchased	No			100	Each	701.0000	1		5/10/05/27	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				ST309		701						
				17566		701						

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IPP Rev:B as

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
NAS1149C0332R		Purchased	No			100	Each	3,848.000	8			
Washer												

ES 05/27

Location	Loc Qty	Loc Code
ST297	3848	
113524	10	
113737	150	
114341	3688	

48

NAS1149C0363R

Purchased

No

100

Each

1,199.000

2



Washer

ES 05/27

Location	Loc Qty	Loc Code
ST297	1199	
113422	35	
113524	464	
113644	200	
113889	500	

12

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Page 4

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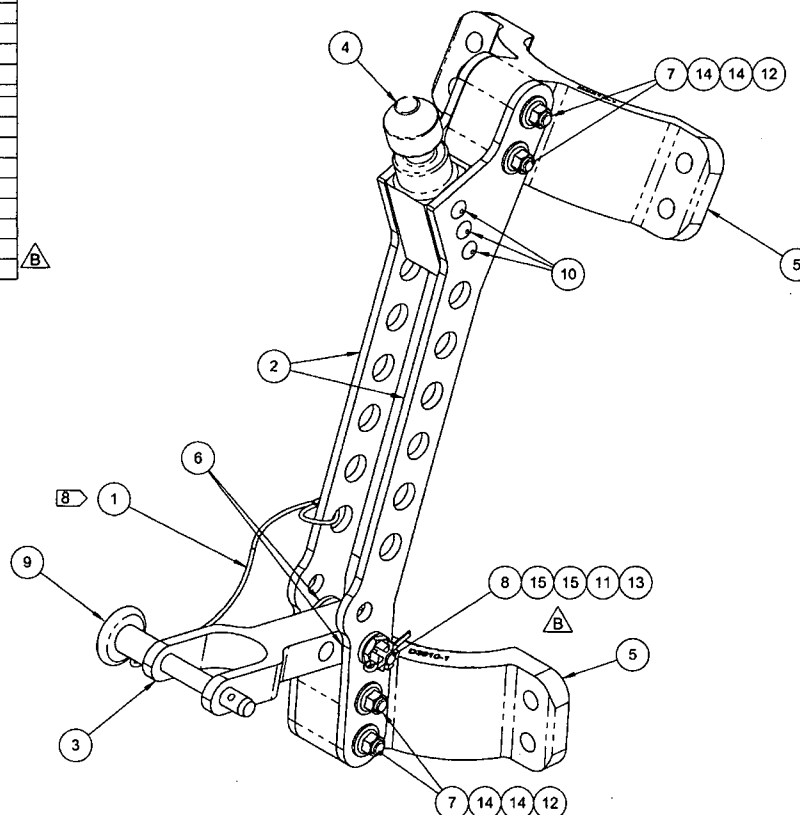
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NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3909-041	FWD X-TUBE LUG ASSY
1	1	D2690-6	LANYARD
2	2	D3909-1	FWD X-TUBE LUG PLATE
3	1	D3909-3	FWD LOWER ATTACH ARM
4	1	D3909-5	EYEBOLT STUD
5	2	D3910-1	X-TUBE LUG
6	2	D3917-1	WASHER
7	4	AN3C12A	BOLT
8	1	AN3C13	BOLT
9	1	MS17984-C413	PIP PIN
10	3	MS20615-4M20	RIVET
11	1	AN310C3	NUT - CASTELLATED
12	4	MS21043-3	NUT
13	1	MS24665-151	COTTER PIN
14	8	NAS1149C0332R	WASHER
15	2	NAS1149C0363R	WASHER



D3909-041 FWD X-TUBE LUG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3909-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.74 lbs
- 8) ATTACH TO D3909-1 BY LOOPING AROUND LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413 PIP PIN'S RING

B	BOM: ADDED ITEM 15 QTY 2 NAS1149C0363R ADDED, ITEM 14 QTY 8 WAS 10. SHT 5, D3909-5 REVISED: SECTION A-A & DIM Ø0.650 REMOVED. SIDE VIEW ADDED. DIM: 2.68 WAS 2.38 REF. 1.30 WAS 1.00, 0.250 WAS 0.220. R0.06 WAS R0.05. WEIGHT REVISED.	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH		
DRAWN	JPH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.04.06		

RELEASED
2010-04-07
JPH

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3909** REV. B
TITLE **FWD X-TUBE LUG ASSY** SCALE NTS

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Dart Aerospace Ltd

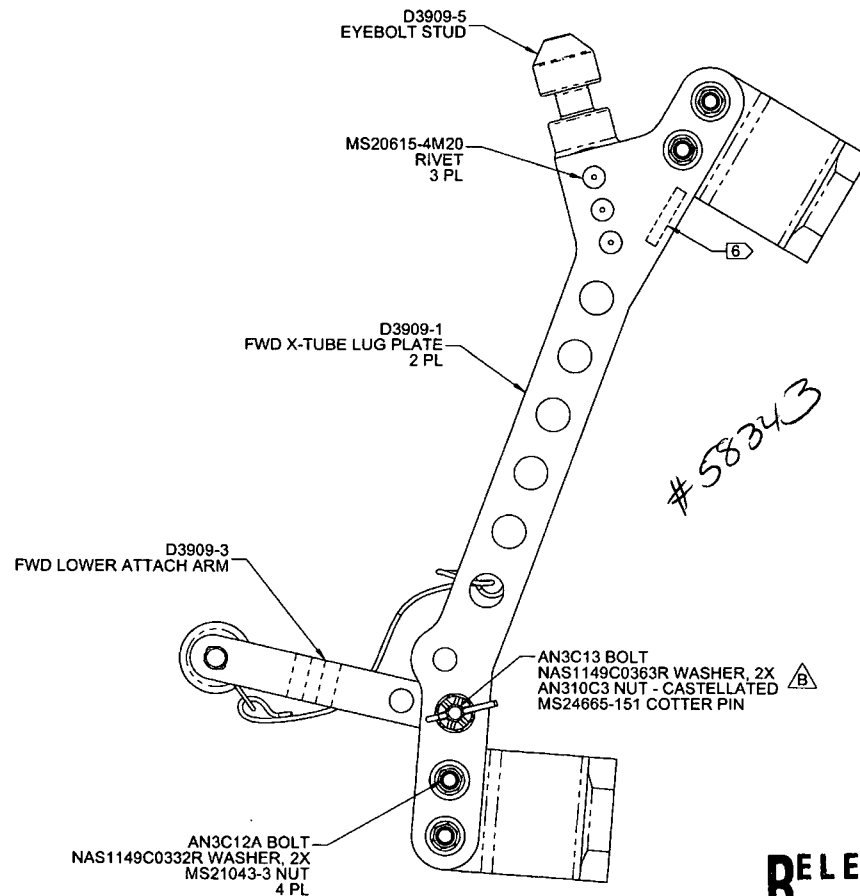
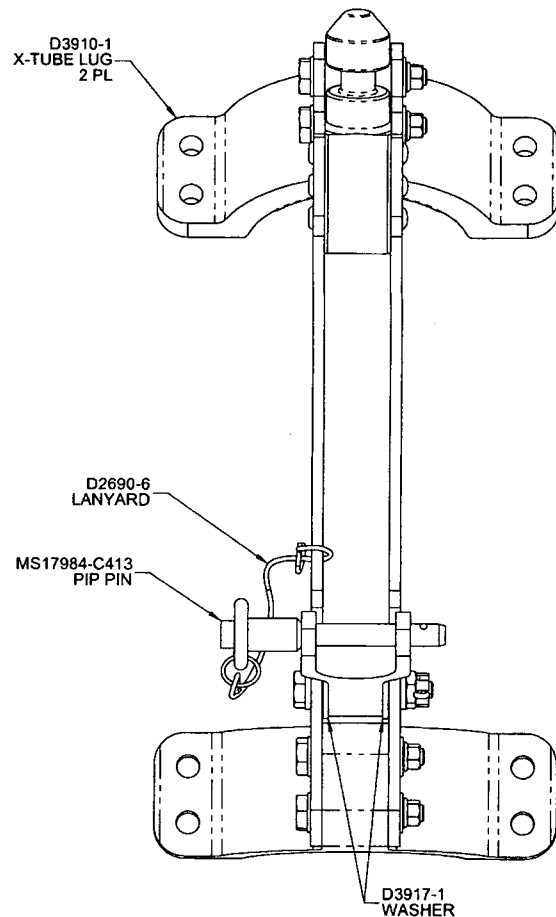
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NOTE: Date & initial all entries



D3909-041 FWD X-TUBE LUG ASSY

RELEASED
2010-04-07
mp

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3909	REV. B
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 5	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FWD X-TUBE LUG ASSY	NTS
DATE	10.04.06	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

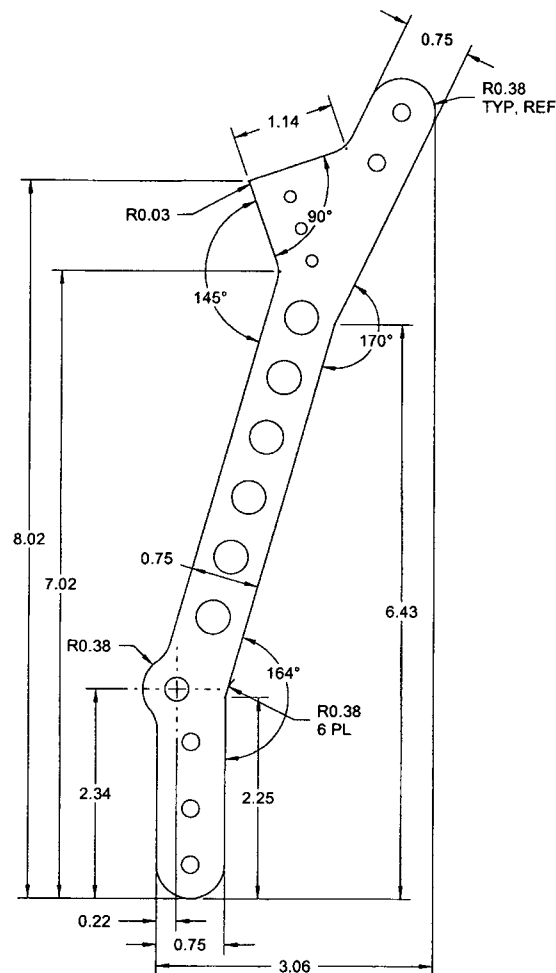
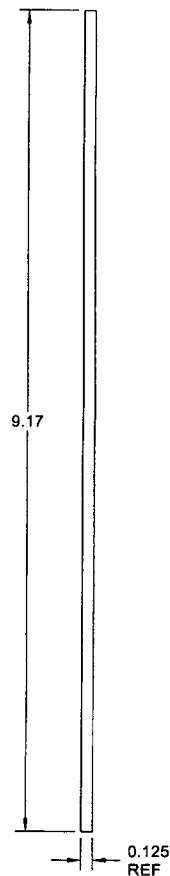
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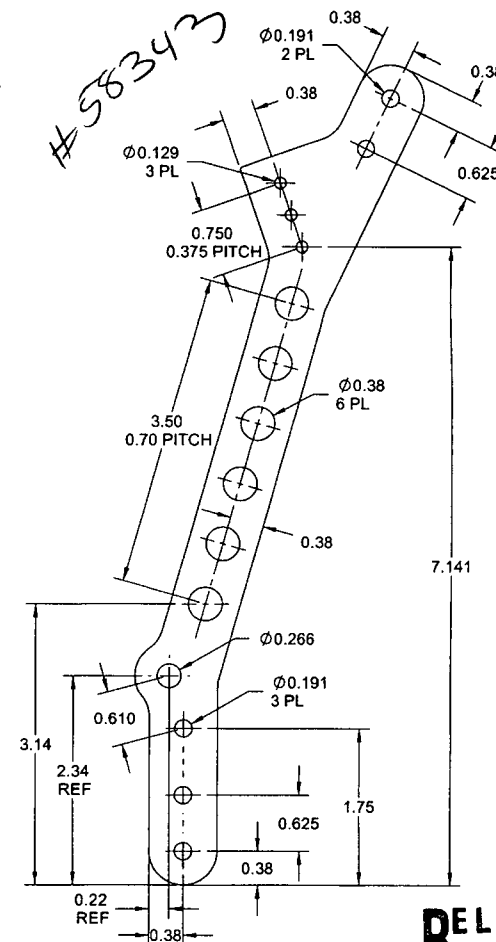
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D3909-1 FWD X-TUBE LUG PLATE



(SUPPLEMENTAL VIEW)

RELEASED
2010-04-07

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET ANNEALED 2B, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 PER DART SPEC M303S11GA OR M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.25 lbs

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3909	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		FWD X-TUBE LUG ASSY	NTS
DATE	10.04.06	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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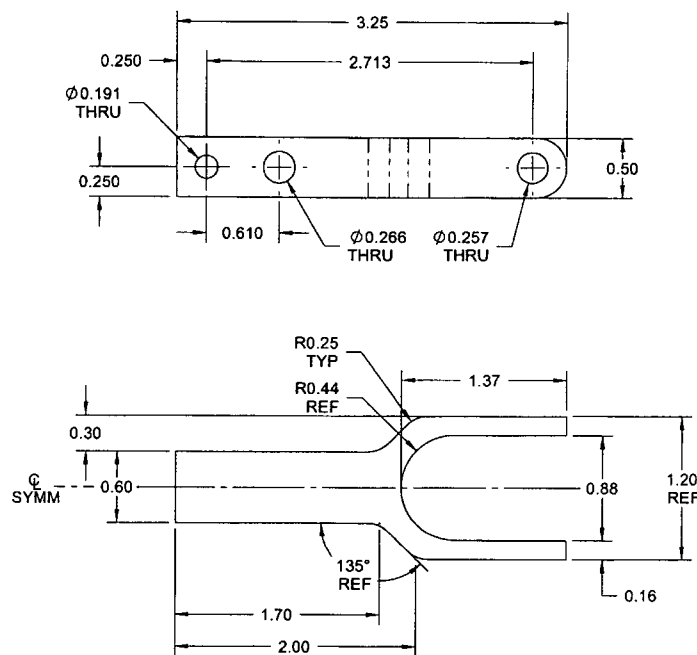
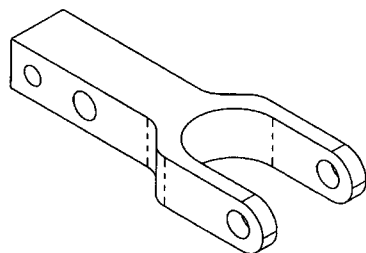
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D3909-3 FWD LOWER ATTACH ARM

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.22 lbs

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JPH	DRAWING NO.	REV. B
MFG. APPR.		D3909	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		FWD X-TUBE LUG ASSY	NTS
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RELEASED
2010-04-07

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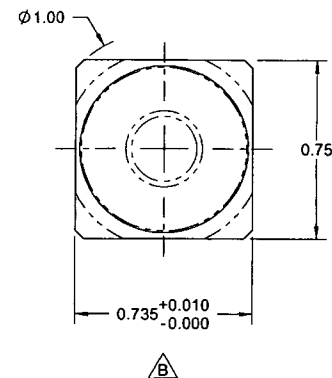
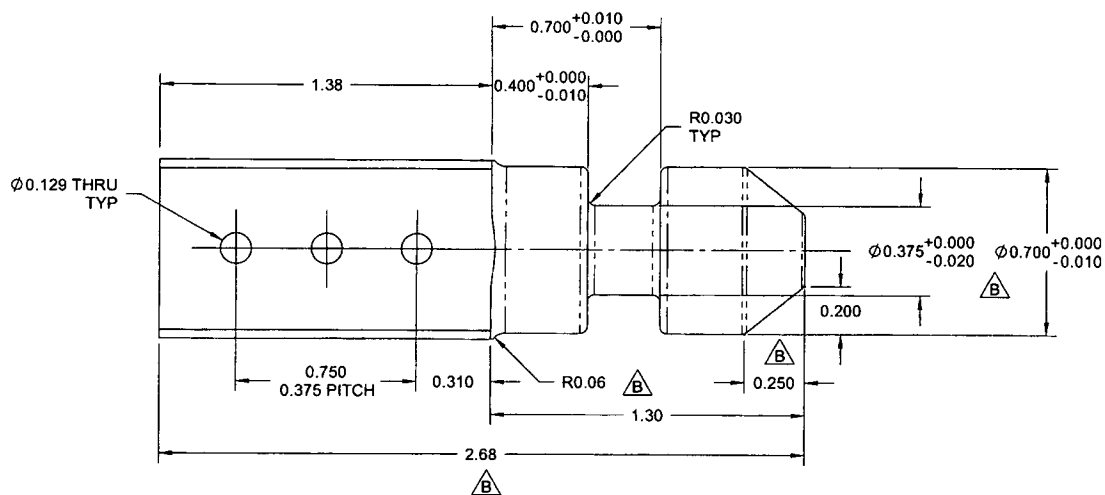
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D

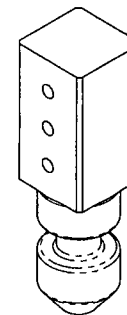
C

B

A



#58343



D3909-5 EYEBOLT STUD

RELEASED
2010-04-07
JMP

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 PER DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3909-5" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.31 lbs

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3909	REV. B
MFG. APPR.	<i>[Signature]</i>	SHEET 5 OF 5	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FWD X-TUBE LUG ASSY	NTS
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8 7 6 5 4 3 2 1

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries